



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada  
  
Tel (613) 632-5200  
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D350-578-011  
Job Sheet 196223



Part No: D350-578-011

Job Qty: 3 pcs ✓

Part Name: AS350/AS355 Bearpaws

Master Unit  
No: 010492.



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/10/19

Job Tracking No:

Due Date: 7/19/19

Created By: Marie Lajeunesse

Type: Stock

Description: SIOP

Note: DWG REV H SHEET 12 IPP Rev:A New Issue 07-01-02 JLM IPP Rev:B 08-01-09 Added Step 2 JLM Verified  
By:EC IPP Rev:C 08-10-15 New Manufacturing Method JLM Verified By:EC

Ship Via:

Bill of Materials

Job Routing

| Op No | Operation              | Qty   | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off |
|-------|------------------------|-------|------------|----------|-----------|---------|-----------------------|-----------|----------|
|       |                        |       |            |          | Setup Hrs | Run Hrs | Workcenter / Supplier | Lead Time |          |
| 160   | Packaging 1 - Pick Kit | 3 pcs | 7/19/19    |          | 0.00      | 0.00    | Packaging 1 - 1       |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 2       |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 3       |           | ✓ Oscar  |
|       |                        |       |            |          |           |         | Packaging 1 - 4       |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 5       |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 6       |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 7       |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 8       |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 9       |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 10      |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 11      |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 12      |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 13      |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 14      |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 15      |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 16      |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 17      |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 18      |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 19      |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 20      |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 21      |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 22      |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 23      |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 24      |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 25      |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 26      |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 27      |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 28      |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 29      |           |          |
|       |                        |       |            |          |           |         | Packaging 1 - 30      |           |          |



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Container No: S208807



Part: D350-578-011

Job No: 196223

Serial No/Batch: S208807

Revision:

Inspector:

Exp Date:

Instructions: TC STC SH93-4 Issue 10, FAA STC SR000281

|                  |       |         |           |                        |  |
|------------------|-------|---------|-----------|------------------------|--|
| 170 QC 4         | 3 pcs | 7/19/19 | 0.00 0.00 | Packaging 1 - 31       |  |
|                  |       |         |           | Packaging 1 - 32       |  |
|                  |       |         |           | Packaging 1 - 33       |  |
|                  |       |         |           | Packaging 1 - 34       |  |
|                  |       |         |           | Packaging 1 - 35       |  |
|                  |       |         |           | Packaging 1 - 36       |  |
|                  |       |         |           | QC 4 - 28              |  |
|                  |       |         |           | QC 4 - 58              |  |
|                  |       |         |           | QC 4 - 69              |  |
|                  |       |         |           | QC 4 - 9               |  |
|                  |       |         |           | QC 4 - 46              |  |
|                  |       |         |           | QC 4 - 68              |  |
|                  |       |         |           | QC 4 - 72              |  |
|                  |       |         |           | QC 4 - 74              |  |
|                  |       |         |           | Packaging 3 - 1 - B4B  |  |
|                  |       |         |           | Packaging 3 - 2 - B4B  |  |
|                  |       |         |           | Packaging 3 - 3 - B4B  |  |
|                  |       |         |           | Packaging 3 - 4 - B4B  |  |
|                  |       |         |           | Packaging 3 - 5 - B4B  |  |
|                  |       |         |           | Packaging 3 - 6 - B4B  |  |
|                  |       |         |           | Packaging 3 - 7 - B4B  |  |
|                  |       |         |           | Packaging 3 - 8 - B4B  |  |
|                  |       |         |           | Packaging 3 - 9 - B4B  |  |
|                  |       |         |           | Packaging 3 - 10 - B4B |  |
|                  |       |         |           | Packaging 3 - 11 - B4B |  |
|                  |       |         |           | Packaging 3 - 12 - B4B |  |
|                  |       |         |           | Packaging 3 - 13 - B4B |  |
|                  |       |         |           | Packaging 3 - 14 - B4B |  |
|                  |       |         |           | Packaging 3 - 15 - B4B |  |
|                  |       |         |           | Packaging 3 - 16 - B4B |  |
|                  |       |         |           | Packaging 3 - 17 - B4B |  |
|                  |       |         |           | Packaging 3 - 18 - B4B |  |
|                  |       |         |           | Packaging 3 - 19 - B4B |  |
|                  |       |         |           | Packaging 3 - 20 - B4B |  |
|                  |       |         |           | Packaging 3 - 21 - B4B |  |
|                  |       |         |           | Packaging 3 - 22 - B4B |  |
|                  |       |         |           | Packaging 3 - 23 - B4B |  |
|                  |       |         |           | Packaging 3 - 24 - B4B |  |
|                  |       |         |           | Packaging 3 - 25 - B4B |  |
|                  |       |         |           | Packaging 3 - 26 - B4B |  |
|                  |       |         |           | Packaging 3 - 27 - B4B |  |
|                  |       |         |           | Packaging 3 - 28 - B4B |  |
|                  |       |         |           | Packaging 3 - 29 - B4B |  |
|                  |       |         |           | Packaging 3 - 30 - B4B |  |
|                  |       |         |           | Packaging 3 - 31 - B4B |  |
|                  |       |         |           | Packaging 3 - 32 - B4B |  |
|                  |       |         |           | Packaging 3 - 33 - B4B |  |
|                  |       |         |           | Packaging 3 - 34 - B4B |  |
|                  |       |         |           | Packaging 3 - 35 - B4B |  |
|                  |       |         |           | Packaging 3 - 36 - B4B |  |
| 185 DC - 1 - B4B | 3 pcs | 7/19/19 | 0.00 0.00 | DC - 1 - B4B           |  |
|                  |       |         |           | DC - 2 - B4B           |  |
| 190 QC 21 - FG   | 3 pcs | 7/19/19 | 0.00 0.00 | QC 21 - FG - 21        |  |
|                  |       |         |           | QC 21 - FG - 70        |  |
|                  |       |         |           | QC 21 - SA - 53        |  |

Part Op 160 - (Pick Kit)

Descriptions: 170 - (QC4- 100% Inspect kits for completeness)

180 - Identify and pack for shipping as per PPP D350-578-011

185 - (Document Control) Photocopy bluefile and create labels per PPP D350-578-011 CHG006

190 - (QC21- Final Inspection - Work Order Release)

F6D13

DAS

70

9-89

AUG 26 2019

MUJ  
8/26/2019

MUJ  
8/26/2019

AUG 26 2019

DAS  
77  
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DAS  
70  
9-89  
AUG 26 2019

DAS  
77  
9-89

F6D13

Master Unit  
No: 010492

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

### Job BOM

| Part / Item           | Component Name    | Quantity         | Operation                  | Container |
|-----------------------|-------------------|------------------|----------------------------|-----------|
| AN4-16A ST343 ✓       | Bolt              | 36 Ea (12 ea) ✓  | 160-Packaging 1 - Pick Kit | ST343-1 ✓ |
| D2432                 | Bearpaw 19" X 24" | 6 pcs (2 ea) ✓   | 160-Packaging 1 - Pick Kit | ST343-1 ✓ |
| D2529 ST008 ✓         | Washer            | 36 pcs (12 ea) ✓ | 160-Packaging 1 - Pick Kit | ST008 ✓   |
| D3601-1 ST042 ✓       | Radius Block      | 36 pcs (12 ea) ✓ | 160-Packaging 1 - Pick Kit | ST042 ✓   |
| D4011-1 ST544 ✓       | Clamp, Short      | 18 pcs (6 ea) ✓  | 160-Packaging 1 - Pick Kit | ST042 ✓   |
| D4012-1 ST545 ✓       | Cushion           | 18 pcs (6 ea) ✓  | 160-Packaging 1 - Pick Kit | ST042 ✓   |
| MS21042L4 ST303 ✓     | Nut               | 36 Ea (12 ea) ✓  | 160-Packaging 1 - Pick Kit | ST303 ✓   |
| NAS1149D0463J ST264 ✓ | Washer            | 72 Ea (24 ea) ✓  | 160-Packaging 1 - Pick Kit | ST264 ✓   |

### Job Allocations

| Operation                  | Component Part | Required | Inventory | Allocated |
|----------------------------|----------------|----------|-----------|-----------|
| 160-Packaging 1 - Pick Kit | AN4-16A        | 36       | 513       | 0         |
|                            | D2432          | 6        | 2         | 0         |
|                            | D2529          | 36       | 472       | 0         |
|                            | D3601-1        | 36       | 108       | 0         |
|                            | D4011-1        | 18       | 5         | 0         |
|                            | D4012-1        | 18       | 296       | 0         |
|                            | MS21042L4      | 36       | 1,856     | 0         |
|                            | NAS1149D0463J  | 72       | 2,942     | 0         |

### Part Specifications

Specifications could not be found.

Plex 6/10/19 10:19 AM Dart.lajeunesse.marie

NCR No.

|                                                                                                                                                                                                                                                                                                                                                                                                       |             |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |
|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--|
| Job: _____<br>Part No. _____                                                                                                                                                                                                                                                                                                                                                                          |             | DISPOSITION<br>Rework <input type="checkbox"/><br>Scrap <input type="checkbox"/><br>Use-as-is <input type="checkbox"/>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |  | DEPARTMENT/PROCESS<br>Skid-tube <input type="checkbox"/><br>Machining <input type="checkbox"/><br>Large Fab <input type="checkbox"/><br>Cross tube <input type="checkbox"/><br>Small Fab <input type="checkbox"/><br>Finishing <input type="checkbox"/><br>Eng. (Non-AW) <input type="checkbox"/><br>Prod. Eng. Coord. <input type="checkbox"/><br>Rec./Store/Packaging <input type="checkbox"/><br>Engineering <input type="checkbox"/><br>Water Jet <input type="checkbox"/><br>Supplier <input type="checkbox"/><br>Quality <input type="checkbox"/> |  |
| Date :                                                                                                                                                                                                                                                                                                                                                                                                | Sequence #: | QTY Affected :                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |  | MRB (QS1042)                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |  |
| Description Work Order Deviation                                                                                                                                                                                                                                                                                                                                                                      |             | Disposition                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |
| <b>Root Cause</b><br><div>Operator <input type="checkbox"/><br/>Manufacturing Process <input type="checkbox"/><br/>Equip/Tooling <input type="checkbox"/><br/>Handling/Preservation <input type="checkbox"/><br/>Material <input type="checkbox"/><br/>Product Improvement <input type="checkbox"/><br/>Process Improvement <input type="checkbox"/><br/>Human Factors <input type="checkbox"/></div> |             | <b>FAULT CATEGORY</b><br><div>Pressure/Forced <input type="checkbox"/><br/>Bending <input type="checkbox"/><br/>Crushing <input type="checkbox"/><br/>Cracks <input type="checkbox"/><br/>Crimp/Kink/Ripple/Wave/Twist <input type="checkbox"/><br/>Marks/Chatter <input type="checkbox"/><br/>Mislabeled <input type="checkbox"/><br/>Other/Details: <input type="checkbox"/></div> <div>Contamination <input type="checkbox"/><br/>Misaligned/off center <input type="checkbox"/><br/>BOM/Route <input type="checkbox"/><br/>Broken/Damage/Defect <input type="checkbox"/><br/>Incomplete/Unclear Instructions <input type="checkbox"/><br/>Drill Holes <input type="checkbox"/><br/>Fit/Function <input type="checkbox"/></div> <div>Power Loss/Surge <input type="checkbox"/><br/>Folio/Program <input type="checkbox"/><br/>Grain Direction <input type="checkbox"/><br/>Weld <input type="checkbox"/><br/>Wrong Stock Pulled <input type="checkbox"/><br/>Out of Sequence <input type="checkbox"/><br/>Off-set/Set-up <input type="checkbox"/></div> <div>Positioned Wrong <input type="checkbox"/><br/>Outside Tolerance <input type="checkbox"/><br/>Drawing <input type="checkbox"/><br/>Finish <input type="checkbox"/><br/>Part Lost/Missing <input type="checkbox"/><br/>Misread <input type="checkbox"/></div> |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |
|                                                                                                                                                                                                                                                                                                                                                                                                       |             |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |
|                                                                                                                                                                                                                                                                                                                                                                                                       |             |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |
|                                                                                                                                                                                                                                                                                                                                                                                                       |             |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |
| Completed By                                                                                                                                                                                                                                                                                                                                                                                          |             | Lead hand / Supervisor                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |
| QC / QA Coordinator                                                                                                                                                                                                                                                                                                                                                                                   |             |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |  |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |  |

5.0 PARTS LIST

5.1 D350-578-011/-013/-015/-017/-021 BEARPAW INSTALLATION

| Qty<br>-011 | Qty<br>-013 | Qty<br>-015 | Qty<br>-017 | Qty<br>-021 | Qty<br>-031 | Part Number   | Description                   |
|-------------|-------------|-------------|-------------|-------------|-------------|---------------|-------------------------------|
| X           |             |             |             |             |             | D350-578-011  | BEARPAW INSTALLATION          |
|             | X           |             |             |             |             | D350-578-013  | BEARPAW INSTALLATION          |
|             |             | X           |             |             |             | D350-578-015  | BEARPAW INSTALLATION          |
|             |             |             | X           |             |             | D350-578-017  | BEARPAW INSTALLATION          |
|             |             |             |             | X           |             | D350-578-021  | BEARPAW INSTALLATION          |
|             |             |             |             |             | X           | D350-578-031  | WEARPLATE KIT                 |
| 2           |             |             |             |             |             | D2432F        | Bearpaw                       |
|             |             | 2           |             |             |             | D2432-3       | Bearpaw                       |
| 12          | 12          | 12          | 12          | 12          |             | D2529         | Washer                        |
|             |             |             |             | 2           |             | D2672F        | Bearpaw                       |
| 12          | 12          | 12          | 12          | 12          |             | D3601-1       | Radius Block (Replaces D2274) |
|             |             |             |             |             | 2           | D3859-041     | Wearplate                     |
| 6           | 6           | 6           | 6           | 6           |             | D4011-1       | Clamp (Replaces D2438)        |
| 6           | 6           | 6           | 6           | 6           |             | D4012-1       | Cushion (Replaces D2182B050)  |
|             | 2           |             |             |             |             | D4297-1       | Bearpaw                       |
|             |             |             | 2           |             |             | D4297-3       | Bearpaw                       |
| 12          | 12          |             |             | 12          | 12          | AN4-16A       | Bolt                          |
|             |             | 12          | 12          |             | 12          | AN4-17A       | Bolt                          |
| 24          | 24          | 24          | 24          | 24          | 24          | NAS1149D0403J | Washer                        |
| 12          | 12          | 12          | 12          | 12          | 12          | MS21042-4     | Nut (or MS21042-4)            |

5.2 D350-578-111/-113/-115/-117/-121 BEARPAW INSTALLATION

| Qty<br>-111 | Qty<br>-113 | Qty<br>-115 | Qty<br>-117 | Qty<br>-121 | Part Number  | Description          |
|-------------|-------------|-------------|-------------|-------------|--------------|----------------------|
| X           |             |             |             |             | D350-578-111 | BEARPAW INSTALLATION |
|             | X           |             |             |             | D350-578-113 | BEARPAW INSTALLATION |
|             |             | X           |             |             | D350-578-115 | BEARPAW INSTALLATION |
|             |             |             | X           |             | D350-578-117 | BEARPAW INSTALLATION |
|             |             |             |             | X           | D350-578-121 | BEARPAW INSTALLATION |
| 1           |             |             |             |             | D350-578-011 | Bearpaw Installation |
|             | 1           |             |             |             | D350-578-013 | Bearpaw Installation |
|             |             | 1           |             |             | D350-578-015 | Bearpaw Installation |
|             |             |             | 1           |             | D350-578-017 | Bearpaw Installation |
|             |             |             |             | 1           | D350-578-021 | Bearpaw Installation |
| 1           | 1           | 1           | 1           | 1           | D350-578-031 | Wearplate Kit        |